

Work Order ID 65611

January 21, 2011 9:48:27 AM

Page 1

Item ID: D4060-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Ski Clamp, Bottom

Start Date: 1/20/11 Start Qty: 6.00

Cust Item ID:

Required Date: 1/27/11 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4060

A

101

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

cut per drwg D4060 Rev.A

304 . 080

B11-1-21

(6)

102

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-1-21

103

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sulaky

(46)

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Page 2

Item ID: D4060-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Ski Clamp, Bottom

Start Date: 1/20/11 Start Qty: 6.00



Cust Item ID:

Required Date: 1/27/11 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

104

0.00



Small Fab

Memo

0.00

SB 11/21/05

(6)

Small Fab

bend per drwg D4060 Rev.A

105

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Sub 127

(x6)

Quality Control

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

u/25

1/16/28 (6)

Quality Control

Work Order ID 65611

January 21, 2011 9:48:28 AM



| | | | | | | |
|----------------|-------------------|------------|------|-------|---------------|--|
| Item ID: | D4060-3 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Ski Clamp, Bottom | | | | | |
| Start Date: | 1/20/11 | Start Qty: | 6.00 | | Cust Item ID: | |
| Required Date: | 1/27/11 | Req'd Qty: | 6.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Identify as per dwg & Stock Location: | 0.00 | | | | | | | |
| | Packaging | | | | | | | | |
| Packaging | Memo SAI HAI | 0.00 | | | | | | | |
| | | 0700 | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| | QC | | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | | |

01/31/11 (6)

11/01/31

MF 11-01-23

Picklist Print

January 21, 2011 9:48:26 AM

Page 1

Work Order ID: 65611



Parent Item: D4060-3



Parent Item Name: Ski Clamp, Bottom



Start Date: 1/20/11

Required Date: 1/27/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue DD 10.02.16 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|--------|
| M304S14GA  | | Purchased | No | | | | sf | 75.3108 | | 0.25 | | | |
| 304SS sheet .080 | | | | | | | | |  | | | | |

13 11-1-21

Location

Loc Qty

Loc Code

MAT20

75.3108

113295

75.3108

113295

(6)

8

7

6

5

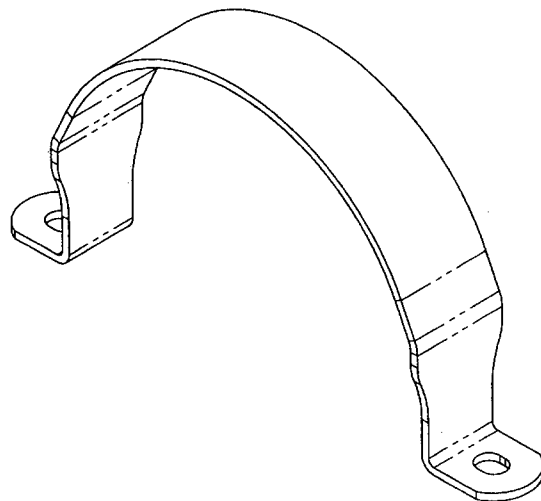
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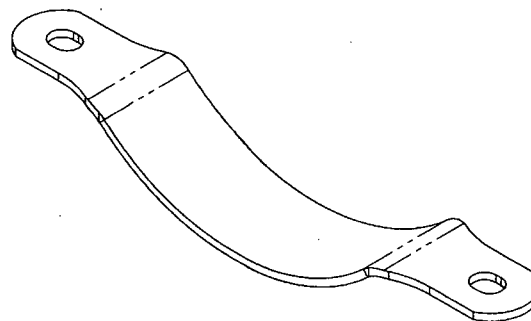
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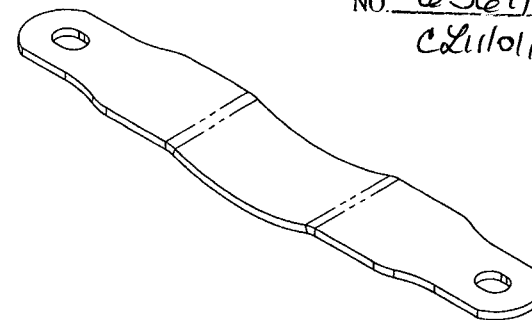
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C21101/20



D4060-1 412 SKI CLAMP, TOP



D4060-3 412 SKI CLAMP, BOTTOM



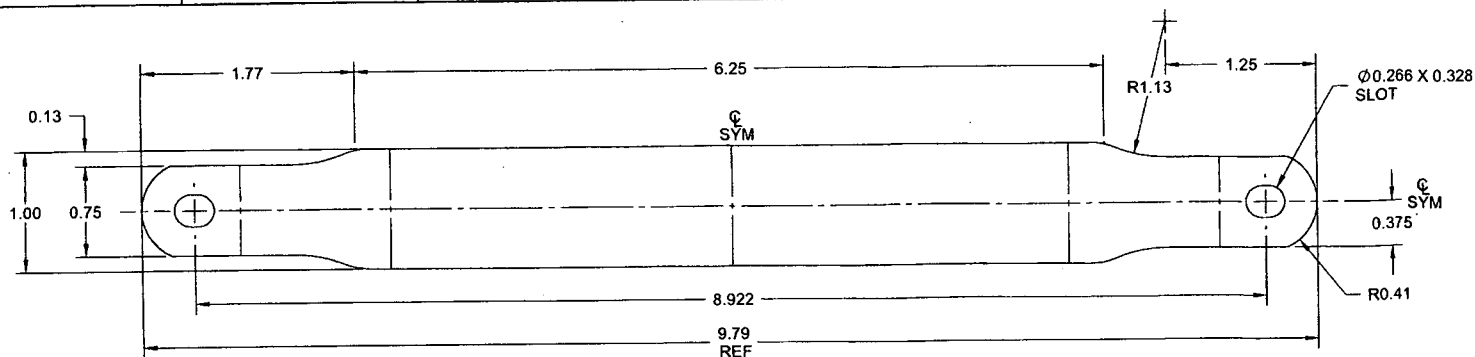
D4060-5 412 SKI CLAMP, AFT

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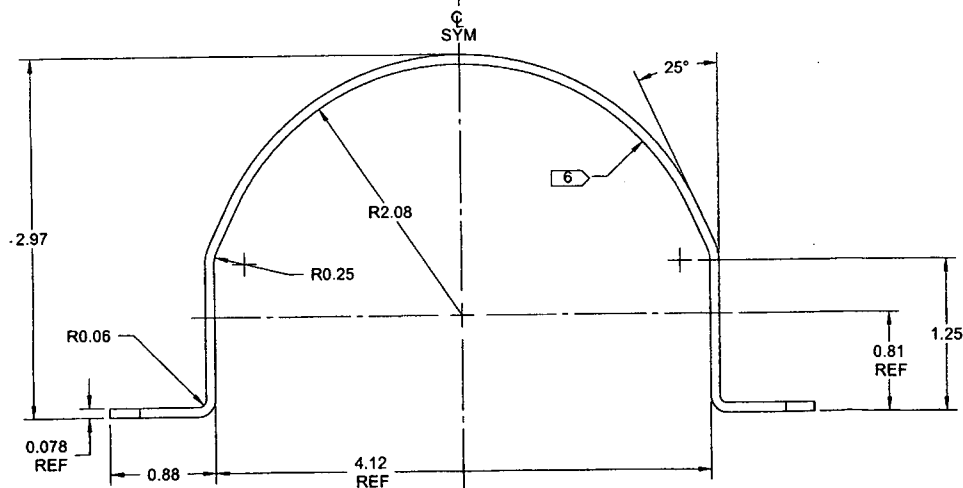
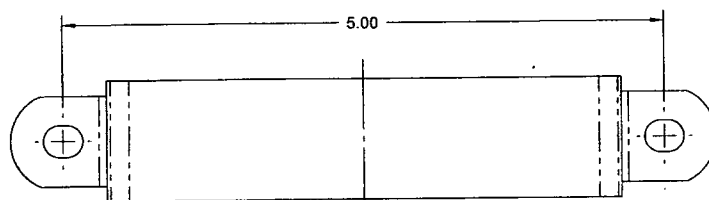
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
 PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
 REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4060-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4060-1 = 0.20 lbs, D4060-3/-5 = 0.12 lbs

| | | | | | |
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| A | | NEW ISSUE | | MB | 10.03.31 |
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D4060-1F 412 SKI CLAMP, TOP FLAT PATTERN

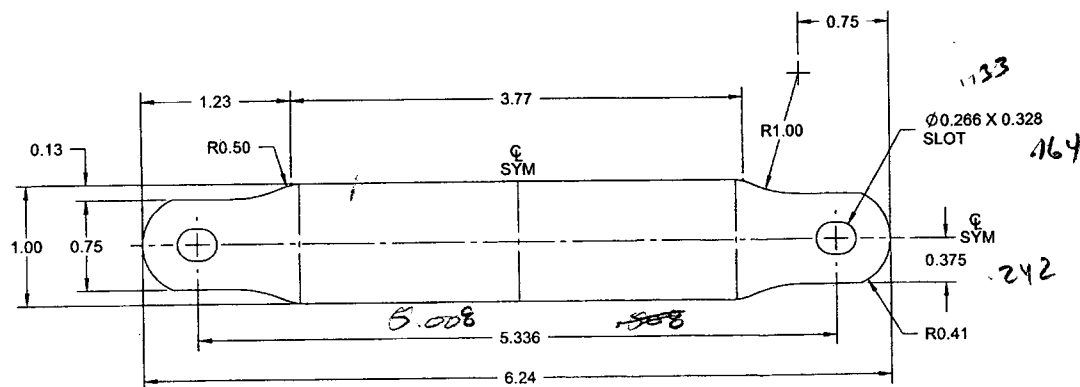


D4060-1 412 SKI CLAMP, TOP
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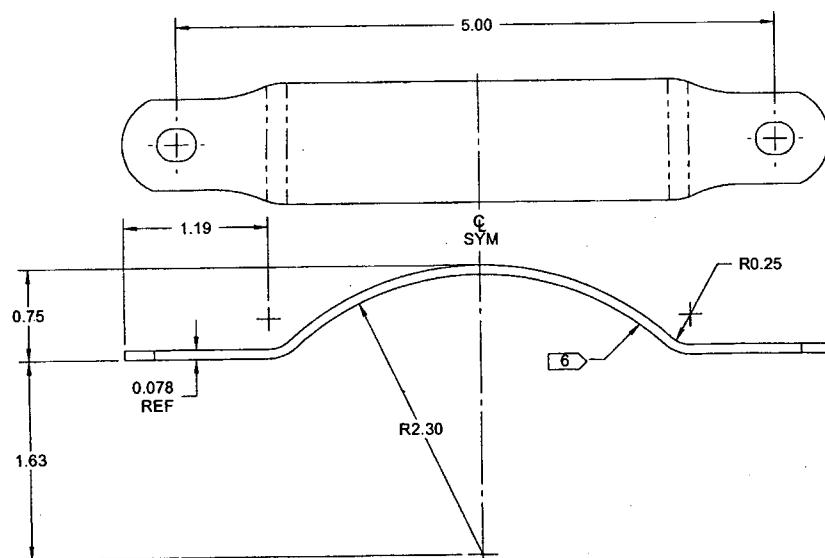
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D4060-3F 412 SKI CLAMP, BOTTOM FLAT PATTERN

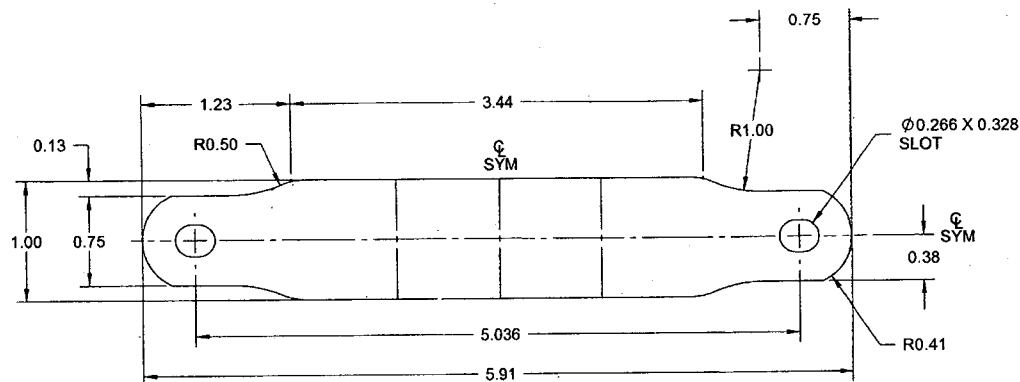


D4060-3 412 SKI CLAMP, BOTTOM
MAKE FROM D4060-3F

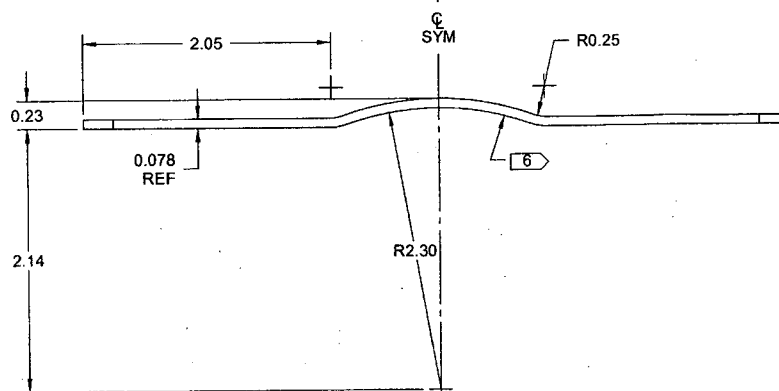
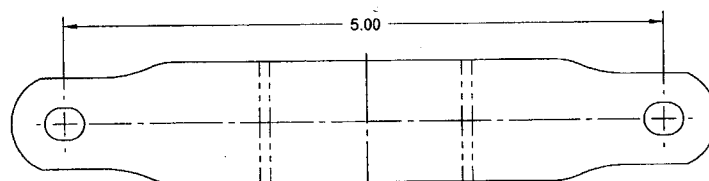
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D4060-5F 412 SKI CLAMP, AFT FLAT PATTERN



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